

Work Order ID 61153

Tuesday, August 10, 2010 8:40:24 AM



Page 1

Item ID: *D2842-041

Accept



Setup Start



Revision ID:

Item Name: Step Assembly, 206 Float

Stop



Start Date: 8/11/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 8/25/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan: *mf*

Date: 10-8-10

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2842	Rev. B								

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut D2842-1 using D2622 extrusion as per Dwg D2842-2-Drill D2842-1 using Jig DT8271 as per Dwg D2842-3-Deburr and bevel ends for welding

10.08.12 *4* *φ*

110

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

Quality Control

10.08.12 *4* *φ*

120

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Weld one end cap and (2) lugs using Jig DT followed by DT as per Dwg D2842-A/R AL Rod Batch: ~~112860~~ 112860 114877 2-Grind end cap weld flush

10.08.12 *4* *φ*

112860
114877

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00							
						10	08.17		
140  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
						4			
						4			
150  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							
						4			

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Page 3

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Required Date: 8/25/2010 Req'd Qty: 4.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				(4)	φ		
				SAD 10-08-18					
170 Large Fab Large Fab	Large Fab Memo 1-Remove alodine prior to welding. <input type="checkbox"/> Weld end cap as per Dwg D2842. <input type="checkbox"/> A/R AL Rod Batch: <u>1112860</u> <input type="checkbox"/> 2-Grind end cap weld flush.	0.00 0.00				4	φ		
				10.08.19					
180 QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00				(4)	PD 10.08.19		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 4

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Item Name: Step Assembly, 206 Float

Start Date: 8/11/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 8/25/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC5- Inspect part completeness to step on W/O

0.00

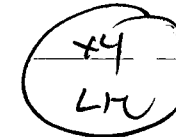
Subs/19

QC

Memo

0.00

Quality Control



191

Chemical Conversion Coat per QSI005 4.1

0.00

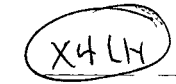
=) JH 10/08/20

HandFinish

Memo

0.00

Hand Finishing



8

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

M115291.

Powdercoat

Memo

0.00

Powder Coating

START TIME: 9:00
OVEN TEMPERATURE: 320°
FINISH TIME: 9:30

4 10-8-24.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 5

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Start Date: 8/11/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 8/25/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00					10	08	25 (4)
220 HandFinish Hand Finishing	HandFinishing Memo 1-Install inserts as per Dwg D2842 2-Wing Walk as per Dwg D2842 and QSI 005 4.1 Batch: <u>115028</u>	0.00 0.00					10	08	25 (4)
230 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				 44			

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Tuesday, August 10, 2010 8:40:24 AM



Page 6

Item ID: D2842-041 Accept  Setup Start 
Revision ID:
Item Name: Step Assembly, 206 Float Stop 
Start Date: 8/11/2010 Start Qty: 4.00  Cust Item ID:
Required Date: 8/25/2010 Req'd Qty: 4.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240  Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo <i>PPP 6/14y</i>	0.00 0.00				<i>10/14/30</i>		<i>(4)</i>	
250  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00						<i>10/08/30</i> <i>CL 10/8/30</i>	<i>[Signature]</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

Tuesday, August 10, 2010 8:40:23 AM

Page 1

Work Order ID: 61153

Parent Item: D2842-041

Parent Item Name: Step Assembly, 206 Float

Start Date: 8/11/2010

Required Date: 8/25/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:D As Per Ecn 766 06-01-06 JLM□□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN960C10L	NAS1149C0332 R	Purchased	No			100	Each	29.0000	3	12			
-----------	-------------------	-----------	----	--	--	-----	------	---------	---	----	--	--	--



washer

B# 109545

Location	Loc Qty	Loc Code
----------	---------	----------

ST245	29	
-------	----	--

107534	29	
--------	----	--

D2622-120C		Manufactured	No			120	Each	95.4200	1	4			
------------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--



Step Extrusion

Location	Loc Qty	Loc Code
----------	---------	----------

WA	95.42	
----	-------	--

55214	3.42	
-------	------	--

58544	92	
-------	----	--

D2734		Manufactured	No			120	Each	7.0000	2	8			
-------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--



Step End Plate



Location	Loc Qty	Loc Code
----------	---------	----------

WA	7	
----	---	--

55014	7	
-------	---	--

D3459-1		Manufactured	No			220	Each	32.0000	2	8			
---------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--



Float Step Mounting Plate

Location	Loc Qty	Loc Code
----------	---------	----------

WA	32	
----	----	--

48138	10	
-------	----	--

51583	22	
-------	----	--

MV 10-08-25

10-08-16

10-08

10-08-12

2
6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Tuesday, August 10, 2010 8:40:23 AM

Page 2

Work Order ID: 61153

Parent Item: D2842-041

Parent Item Name: Step Assembly, 206 Float

Start Date: 8/11/2010

Required Date: 8/25/2010

Start Qty: 4.00

Required Qty: 4.00

D3459-3

 Float Step Mounting Plate

Manufactured No

120 Each

18.0000

2 8



10.08.16

Location

Loc Qty

Loc Code

WA

361214

18

2

46988

1

51630

17

6

MS27039C1-07

 screw

Purchased No

220 Each

21.0000

3



12

115460

Location

Loc Qty

Loc Code

ST293

21

111424

21

10.08.25

NAS1329C3KB130

 insert

Purchased No

220 Each

84.0000

3



12

Location

Loc Qty

Loc Code

ST276

84

111981

84

10.08.25

NAS1515H3L

 WASHER

Purchased No

220 Each

434.0000

3



12

Location

Loc Qty

Loc Code

FG

40

102472

40

ST277

394

111819

148

113362

246

10.08.25

Tuesday, August 10, 2010 8:40:23 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQÁ: _____ Date: _____

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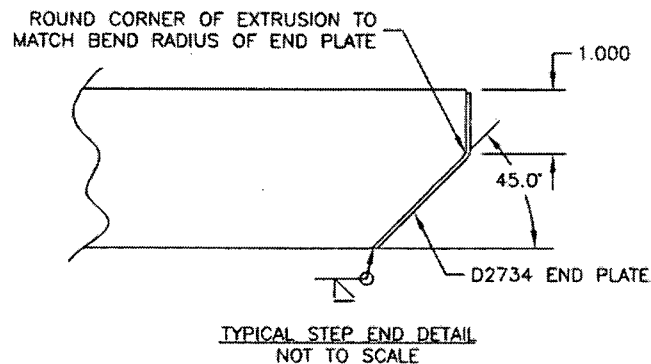
NOTE: Date & initial all entries

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QTY - 041	QTY - 042	PART NUMBER	DESCRIPTION
X		D2842-041	LH STEP ASSEMBLY
	X	D2842-042	RH STEP ASSEMBLY
1	1	D2622-11B	EXTRUSION
2	2	D2734	END PLATE
2	2	D3459-1	PLATE
2	2	D3459-3	PLATE
3	3	NAS1329C3KB130 (OR AESS10KB130)	INSERT
3	3	MS27039C1-07	SCREW
3	3	NAS1515H3L	WASHER
3	3	AN950C10L	WASHER

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DAFT

$$\begin{array}{r} 22.31 \\ 17.45 \\ \hline 39.76 \\ 1.10 \\ \hline 40.86 \end{array}$$

DESIGN KE	PH	DARI AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED 	APPROVED 	DRAWING NO. D2842	REV. B SHEET 1 OF 1
DATE 05.09.23		TITLE 206L/407 FLOAT STEP ASSEMBLY	SCALE NTS
A	98.10.13	NEW ISSUE	
B	05.09.23	RE-DESIGN, ADD D3459-1/-3	

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